

Date: Friday, 6/16/2006 1:44:38 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 27594		
Estimate Number	: 10892		
P.O. Number	: NIA	Part Number	: D32861
This Issue	: 6/16/2006 S.O. No. : NIA	Drawing Number	: D3286 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 6/15/2006 Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: NIA	Material	: NIA
Written By	: <u>See Comment Below</u>	Due Date	: 6/30/2006
Checked & Approved By	: <u>[Signature]</u>	Qty:	50 Um: Each
Comment	: Est A 04.07.14 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S11GA	304/316 .125 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.0740 sf(s)/Unit Total : 3.7000 sf(s)
 304/316 .125 Sheet

M6789

M 06 06 21

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

M 06 06 21

(50)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 06 06 21

(50)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J 06 06 22

50

M

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Deburr

Form as per Dwg D3286

D 8B 06/06/23

D H.M 06-06-22

(49)

(49)

6.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

J 06-06-26

48

Date: Friday, 6/16/2006 1:44:38 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 27594

Part Number: D32861

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57420

20/6/27 (49)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/06/28 (49)

Job Completion



W 06-06-27

Date: Thursday, 6/15/2006 1:51:36 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 27594		
Estimate Number	: 10892		
P.O. Number	:	Part Number	: D32861
This Issue	: 6/15/2006	S.O. No. :	Drawing Number : D3286 REV A
Prsht Rev.	: NC		Project Number : N/A
First Issue	: //	Type	: PURCHASED PARTS
Previous Run	:	Drawing Revision	: A
		Material	:
Written By	:	Due Date	: 6/30/2006
Checked & Approved By	:	Qty:	50 Um: Each
Comment	: Est A 04.07.14 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0 PG

PURCHASING



Comment: PURCHASING

~~Order (2) D3286-1 per (1) skid tube assembly~~~~Issue P/O.~~

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3286

Material release note is required

Material: 304SS .125" Thick

(.074 SF)

Batch:

2.0 D32861F

Doubler



Comment: Qty: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Doubler

3.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0 QCB

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0 BRAKE NC

NC BRAKE


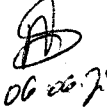




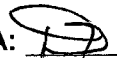
Comment: NC BRAKE

Deburr

Form as per Dwg D3286

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/06/22	2	1 piece was damaged	 <small>06/06/22</small>	Scrap + destroy	SB 06/06/22	 06/06/22	 06/06/22	 06/06/22

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/06/22

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:51:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 27594

Part Number: D32861

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

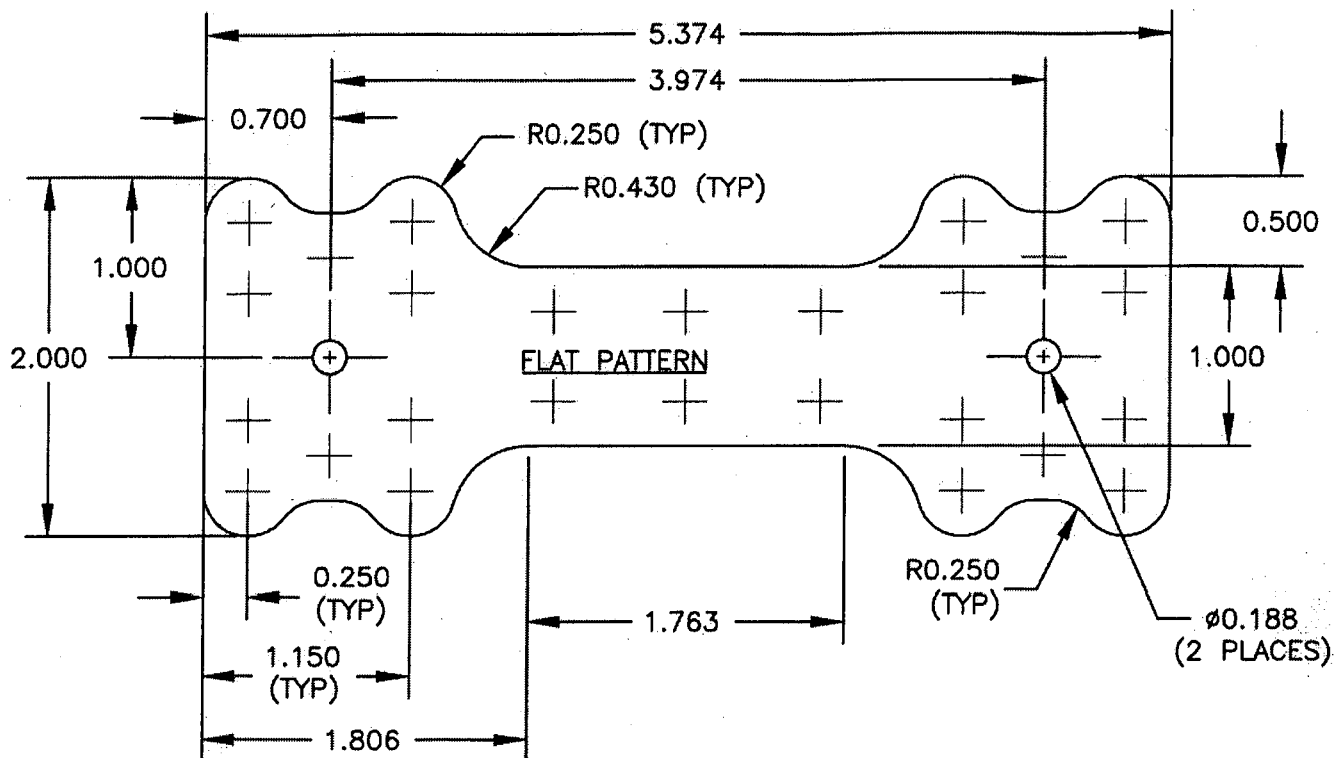
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

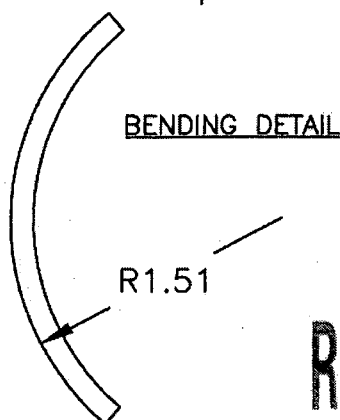
QA: N/C Closed: _____ Date: _____



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3286	REV. A SHEET 1 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1
A	04.05.06	NEW ISSUE	



+ INDICATES LOCATION OF RIVET HOLES. SHOWN FOR REFERENCE ONLY, DO NOT DRILL.



RELEASED
04.06.22 #

D3286-1 DOUBLER

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK
(REF DART SPEC. M304S11GA)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

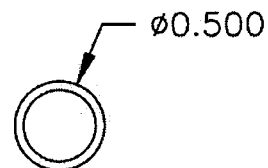
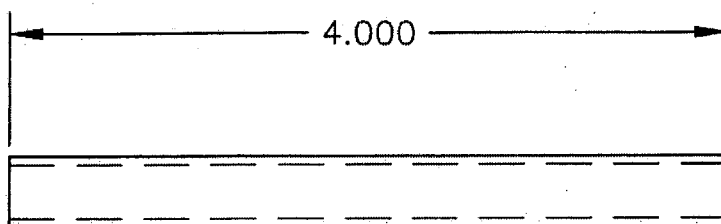
SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 27594

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3286	REV. A SHEET 2 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1



D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL
(REF DART SPEC. M304TRO.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
04.06.22

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